

Work Order ID 65921-4

Thursday, January 27, 2011 10:47:15 AM



Page 1

Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-01-27 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3916

A

100

Weld per dwg A/R S.S. rod Batch: 115728 0.00



Large Fab

Large Fab

Memo

- 1- Cut tube 50"
- 2- Bend tube with manual pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

0.00

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

11-03-01

11-03-03

11-03-02

110 → 2x

17

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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11/02/17	ST 100	Found After welding D3755-1 Bushing that the D3716-01 Rib wasn't been enough when put against DT 9567 the Rib shows it wasn't bent enough in the Last Bone. R.C. back at Attention when bending Rib - (not checked correctly to DT 9567)						

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Item ID: D3916-041

Accept

Revision ID:

Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



8.14.03/02

8.14.03/02

(17)

(12)

11.03.02 (2)

11/03/03

MF 11-03-03

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Picklist Print

Thursday, January 27, 2011 10:47:28 AM

Page 1

Work Order ID: 65921

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 1/27/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured No

100

Each

9.0000

7

42



Bushing



B66125 (39)

~~B65924~~

~~B65900~~ (10)

~~B66489~~ (10)

26.31158 61.3938

B66489 (10x)

11-03-02

M304TS0.750W.049

Purchased

No

100

f

92.0831

4.166

26.31158

61.3938



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

WA

9

54072

9

Location

Loc Qty

Loc Code

MAT

55.13726794

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

21.7876

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765

71116119

END BAR
Scrap

61.3938

3.000

61.3938

SAD 11-03-02

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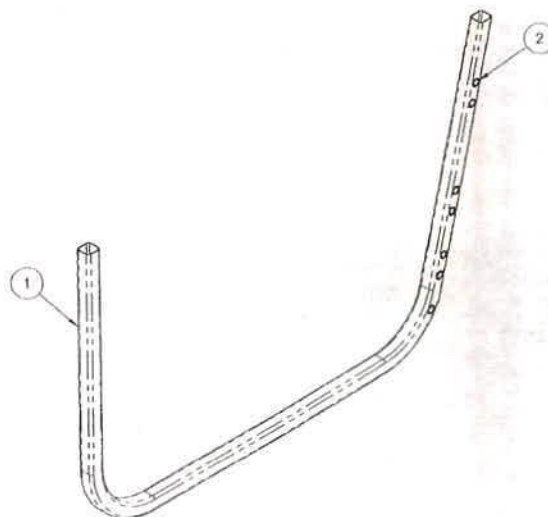
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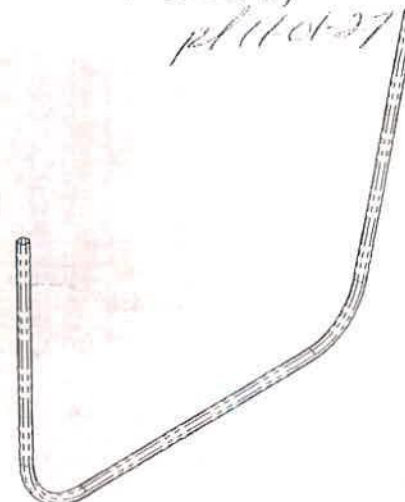
NOTE: Date & initial all entries

ITEM	QTY -041	PIN	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOWN IN
RIBS
PICKING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHIN 90 DAYS
WORK ORDER
NO. 259.11
pl 110-27



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK 10.12.21
UNDER REVIEW
ADDITION OF HOLE + BUSHING
ON D3916-041-1 RIBS.
RELEASED
2010-03-12
JMP

REV	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	JPH			
CHECKED	JPH			
MFG. APPR.	JPH			
APPROVED	JPH			
DE APPR.	JPH			
DATE	10.03.04			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3916
REV. A
SHEET 1 OF 4
TITLE RIB ASSY, 350 BASKET
SCALE NTS
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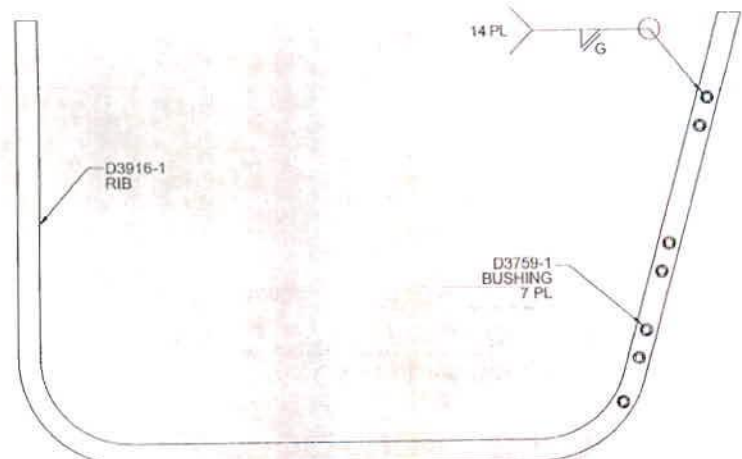
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U-1065921



D3916-041 RIB ASSY

RELEASED
2010-03-12
AMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

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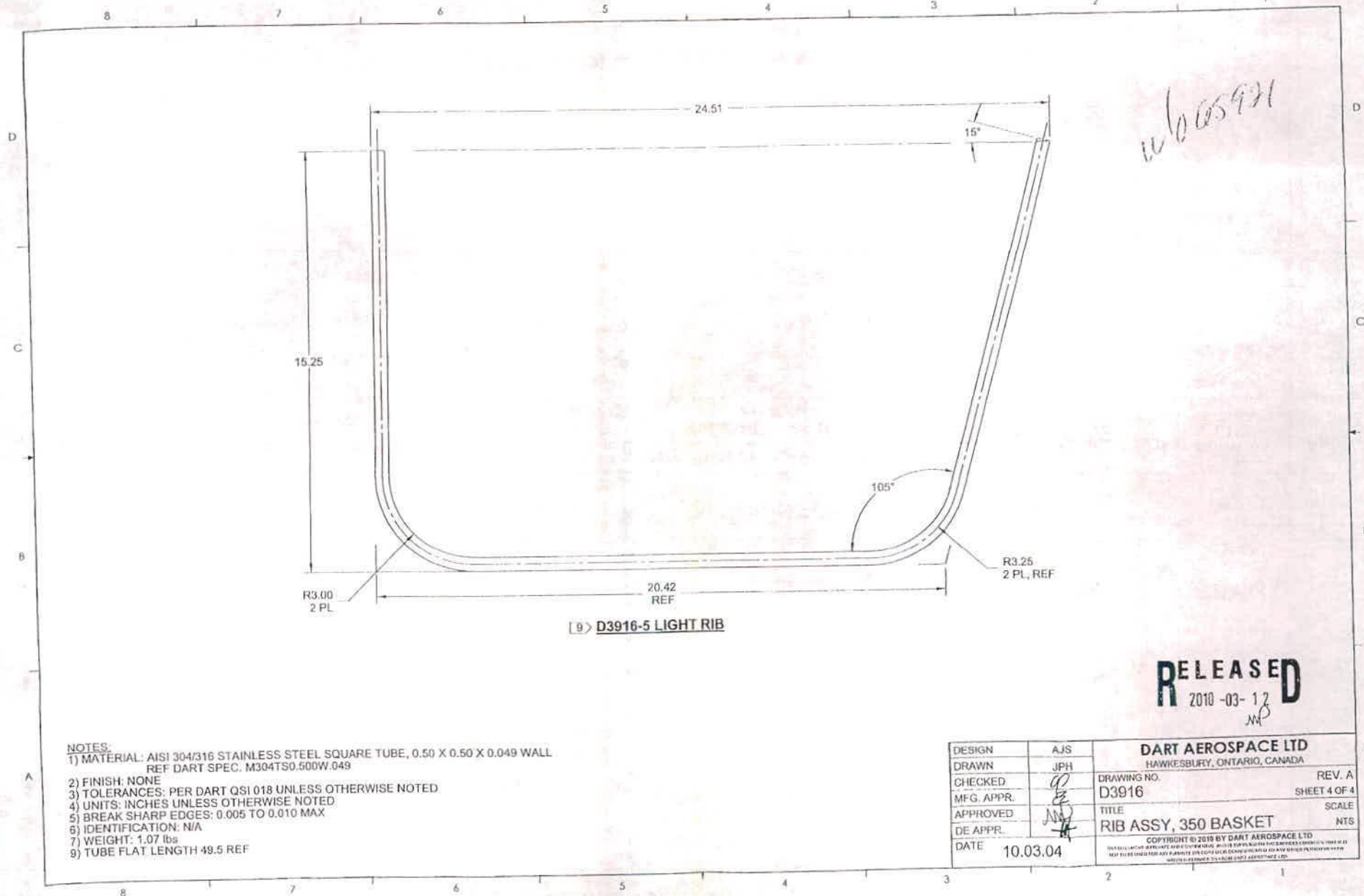
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